

Date: Friday, 6/1/2007 1:02:21 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARSHOE
Job Number	32735			
Estimate Number	12740			
P.O. Number	N/A		Part Number	D353523
This Issue	6/1/2007	S.O. No.	Drawing Number	D3535 UNDER REVIEW
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type	Drawing Revision	A B
Previous Run	32411		Material	N/A
Written By			Due Date	6/8/2007
Checked & Approved By			Qty:	20
Comment	Est Rev.A New Issue 07-02-15 JLM		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		 Comment: Qty.: 1.4296 sf(s)/Unit Total: 28.5915 sf(s) 304/316 .040 Sheet (M304S20GA) Batch: M101264 ML010603
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B ml 07 06 04 SAD 07 106 104 (3) 2-Deburr if necessary MF 07-06-19
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 1/11 07 06 16
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK S 07/06/18
5.0	BRAKE NC	NC BRAKE
		 Comment: NC BRAKE 1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-23 MF 07-06-20 SB 07/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 6/1/2007 1:02:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32735

Part Number: D353523

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JK
7/06/21

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BL/M-J 07-06-21

(20)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fd
07/06/21 (20)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-18

m-f 07/06/21

(20x)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/22

(20)

Job Completion



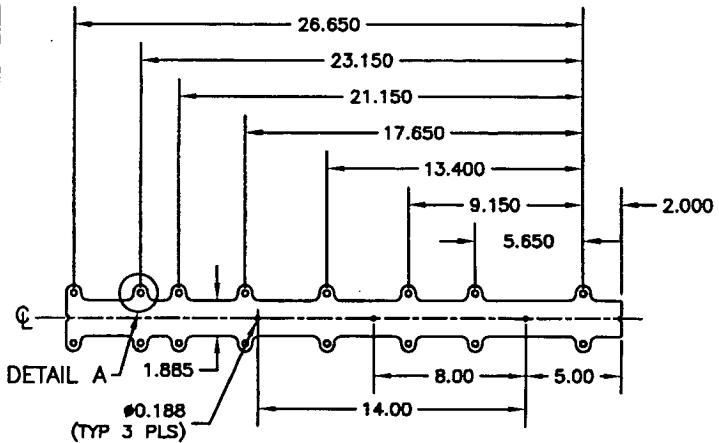
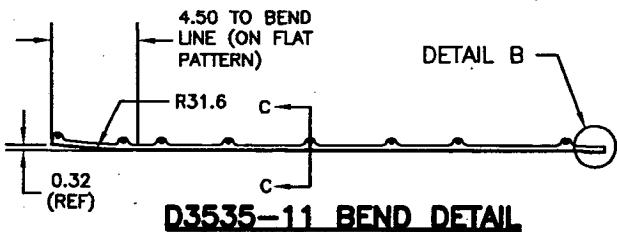
U 07/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

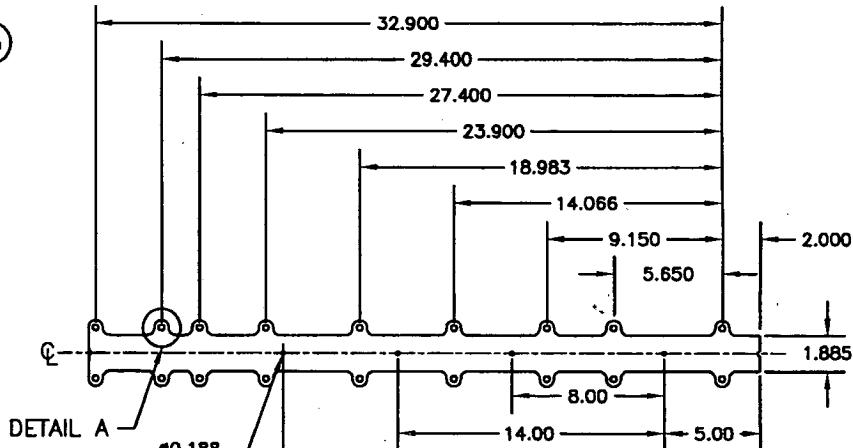
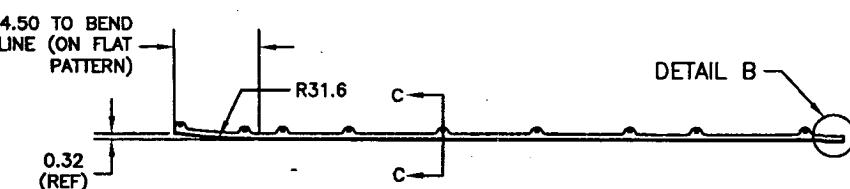
NOTE: Date & initial all entries

DART**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

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WITHOUT NOTICE
WORK ORDER
NO 22135

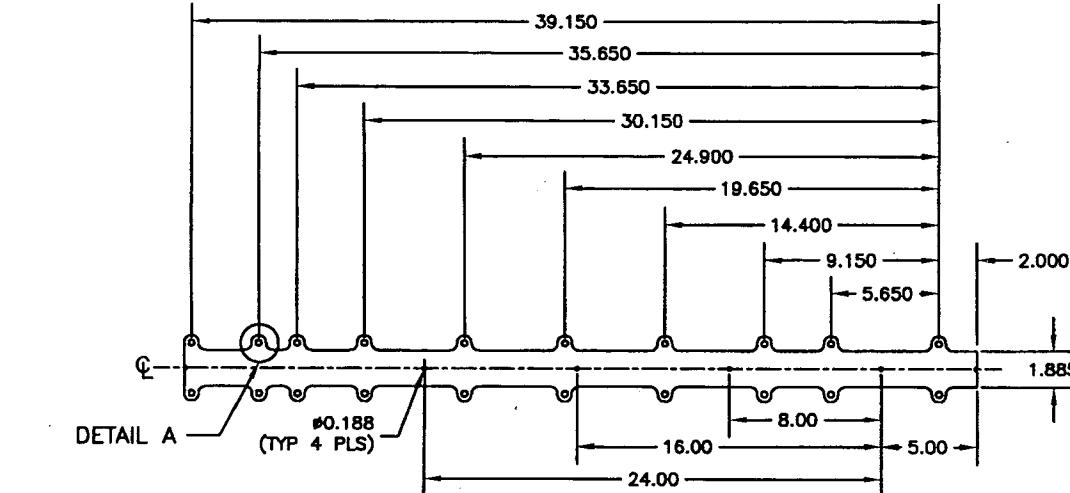
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C8	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>PH</i>	<i>PH</i>	D3535
DATE		TITLE
07.04.17	06.10.25	NEW ISSUE
B	07.04.17	WEARSHOE
		SCALE
		1:10

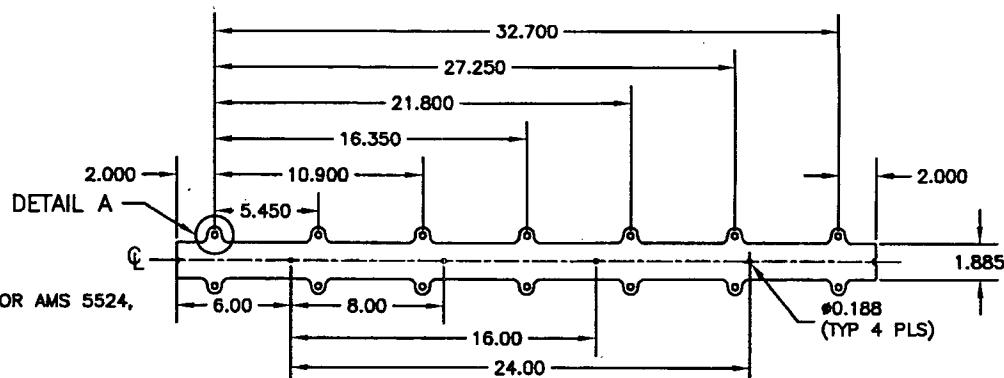
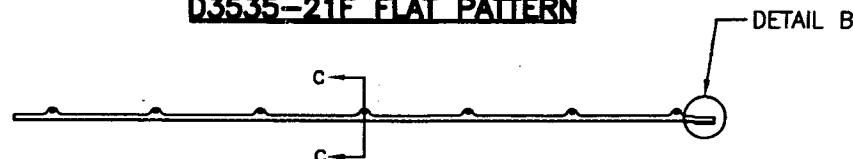
RELEASED
57.04.24

DARTRELEASED
07.04.24**D3535-15F FLAT PATTERN**4.50 TO BEND
LINE (ON FLAT
PATTERN)0.32
(REF)**D3535-15 BEND DETAIL**

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NOTES

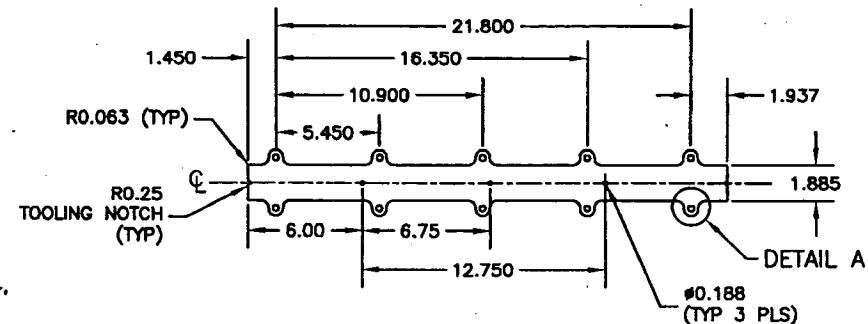
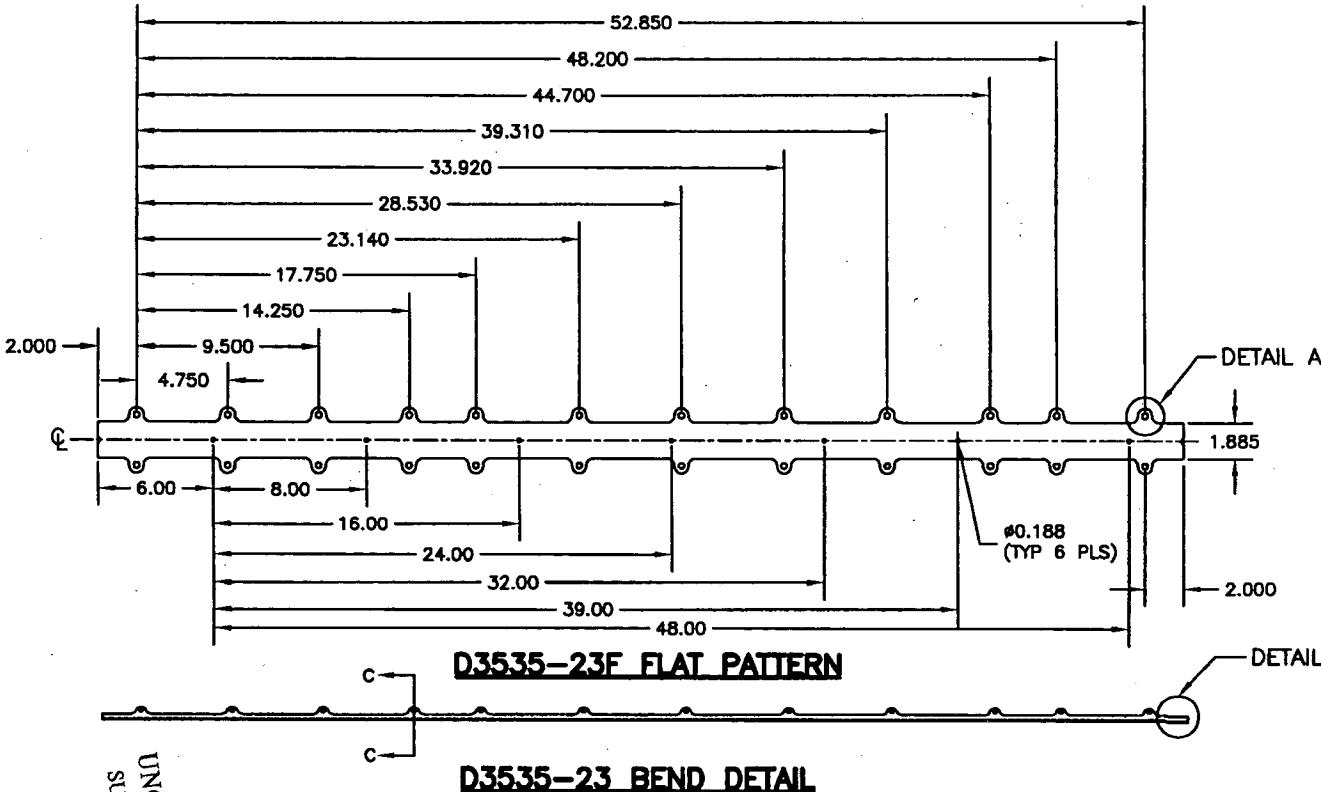
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \mathcal{Q}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
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CHECKED	APPROVED	DRAWING NO.
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DATE		WEARSHOE
		SCALE
		1:10

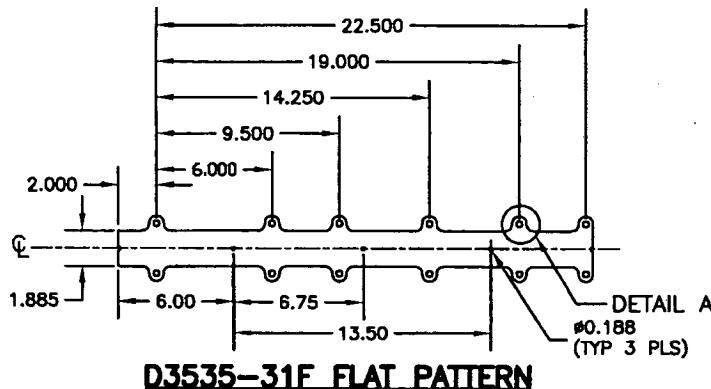
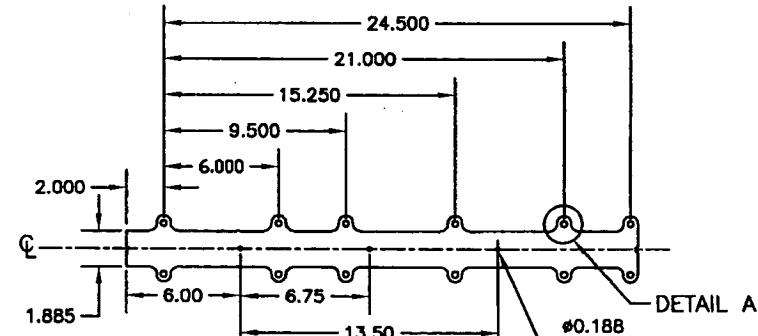
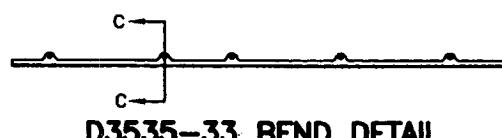
DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
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MM	MM	D3535
DATE		TITLE
07.04.17		WEARSHOE
		SCALE
		1:10

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07.04.24

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NO 24735

- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
 - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT C
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES TO 0.010 MAX
 - 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
 - 8) SEE PAGE 7 FOR DETAILS AND SECTION

DARTRELEASED
07.04.17**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL****D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL**

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NOTES

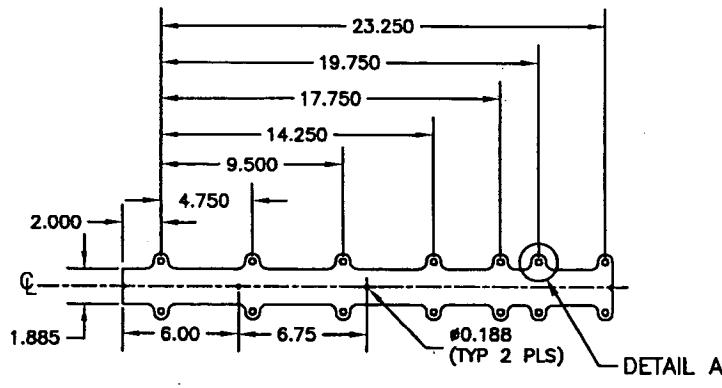
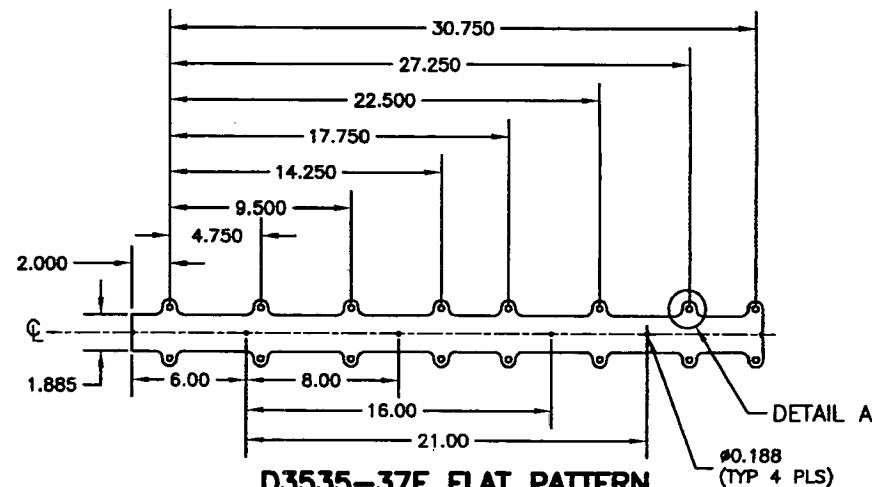
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- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3535	DATE 07.04.17
		TITLE WEARSHOE	SCALE 1:10

DART

RELEASED

07.04.24

**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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NOTES

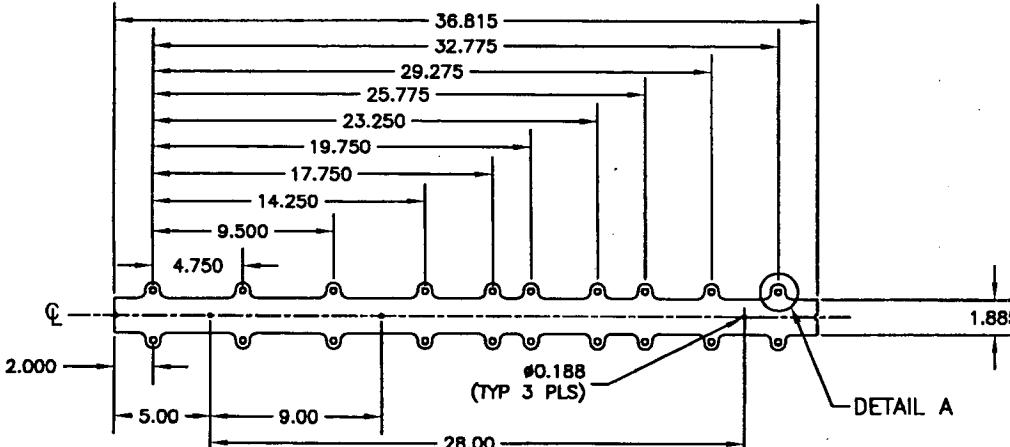
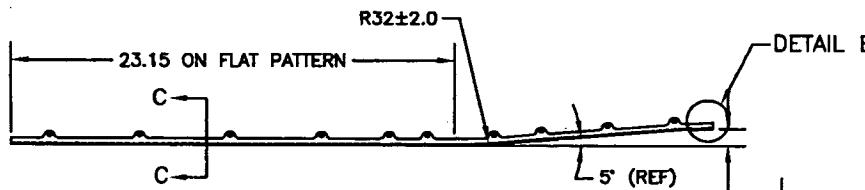
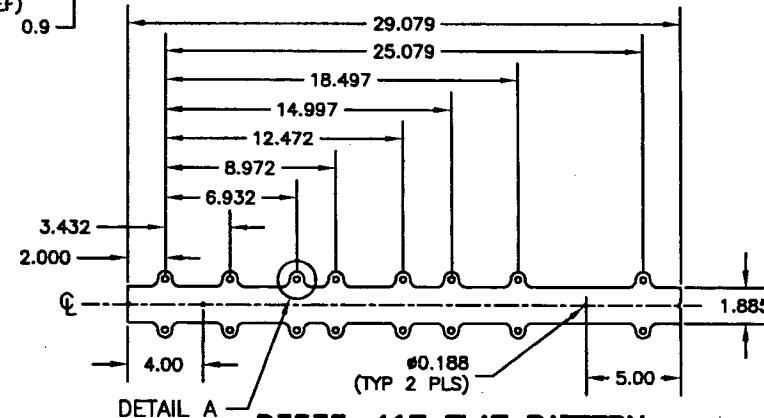
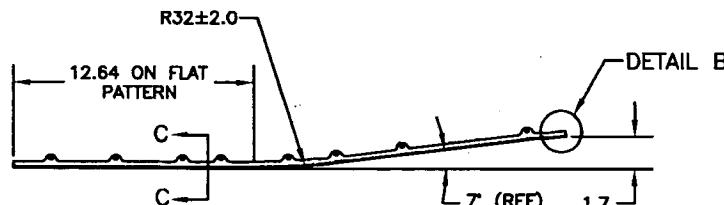
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(REF DART SPEC M304S20GA)
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PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN C.B	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>TH</i>	APPROVED <i>TH</i>	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 5 OF 7 SCALE 1:10

DART

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07.04.24

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C8	PH	PORT HADLOCK, WA
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#	#	D3535
DATE		WEARSHOE
07.04.17		
REV. B		SHEET 6 OF 7
SCALE		1:10

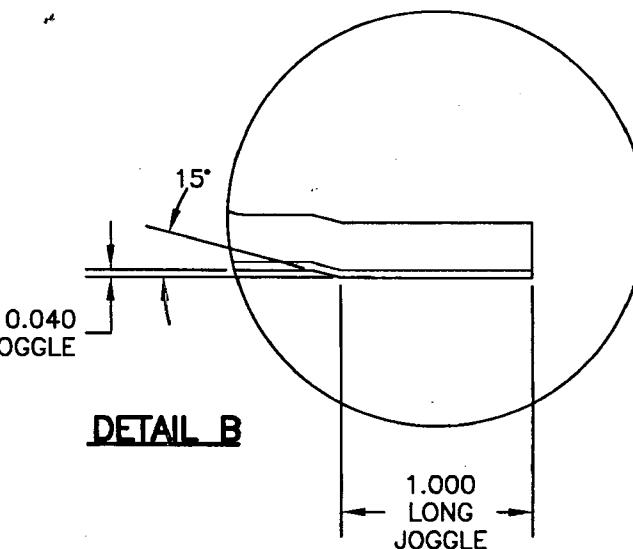
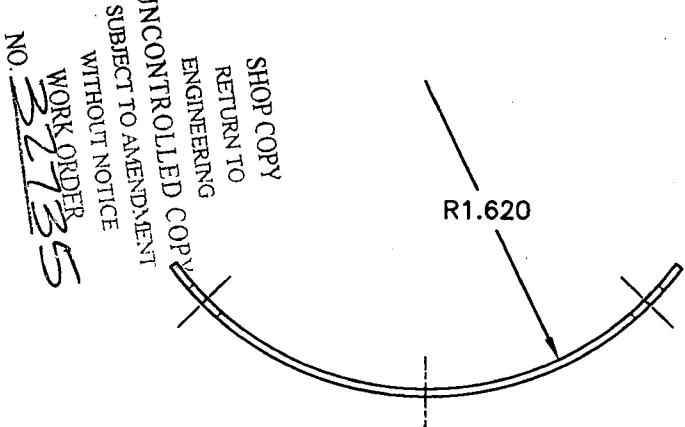
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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT Q
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART**RELEASED**
07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE		SHEET 7 OF 7
07.04.17		SCALE
		1:1

**DETAIL B****SECTION C-C**

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DART AEROSPACE LTD

Work Order: 32735

Description: Wear shoe

Part Number: D3535-23

Inspection Dwg: D3535 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.188$	$+0.005-0.00$	0.190	✓		VERN	
B 0.300	$+1-0.010$	0.301	✓		VERN	
C 0.300	$+1-0.010$	0.301	✓		VERN	
D 1.885	$+1-0.010$	1.888	✓		VERN	
E 52.850	$+1-0.010$	52.850	✓		M.T	
F 8.00	$+1-0.030$	8.00	✓		M.T	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	MM
Date:	07/06/16

Audited by:	SP
Date:	07/06/16

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	